

SM 30

Work Order ID 77358

December-06-11 10:28:50 AM

77358

Page 1

Item ID: D3272-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Step

Stop

NS2

Start Date: 06/12/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/12/06 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3272	Rev B

100	0.00
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100	Large Fab
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Large Fab	Memo	0.00
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SQUARE ONE END BEFORE CUTTING OTHER END

11-12-16

10 Ø

Large Fab	Memo	0.00
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1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

110	QC6- Inspect dimensions to drawing	0.00
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110	Memo	0.00
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QC		
----	--	--

Quality Control		
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Op 11-12-19

10X Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77358***77358***

Page 2

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Accept

N900040100

Setup Start

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Revision ID:

Item Name: Step

Stop

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Start Date: 06/12/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Identify as per dwg & Stock Location: W14

0.00

120

Packaging

Packaging

Memo

0.00

*6/12/19**10 8*

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Quality Control

Memo

0.00

*11/12/19 JJ**6/12/19 CO*

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NOTE: Date & initial all entries

Picklist Print

December-06-11 10:28:53 AM

Page 1

Work Order ID: 77358

77358

Parent Item: D3272-1

D3272-1

Parent Item Name: Step

Start Date: 06/12/2011

Required Date: 30/01/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	126.5200	1	10	**	11.12.14	

D2622-120C

Step Extrusion

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
HALL	17.02	
46910	2	
64409	6	
66970	7.7	
68293	0.5	
72131	0.82	
WA	109.5	
<u>75781</u>	<u>109.5</u>	<u>10</u>

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NOTE: Date & initial all entries

DART

DESIGN <i>QP</i>	DRAWN BY <i>AB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>TH</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01 NEW ISSUE		
B	07.05.18 D3272-1 WAS D2622-120		

RELEASED

07.06.04 *TH*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

B

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 77358 M.L.J

11/12/06

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

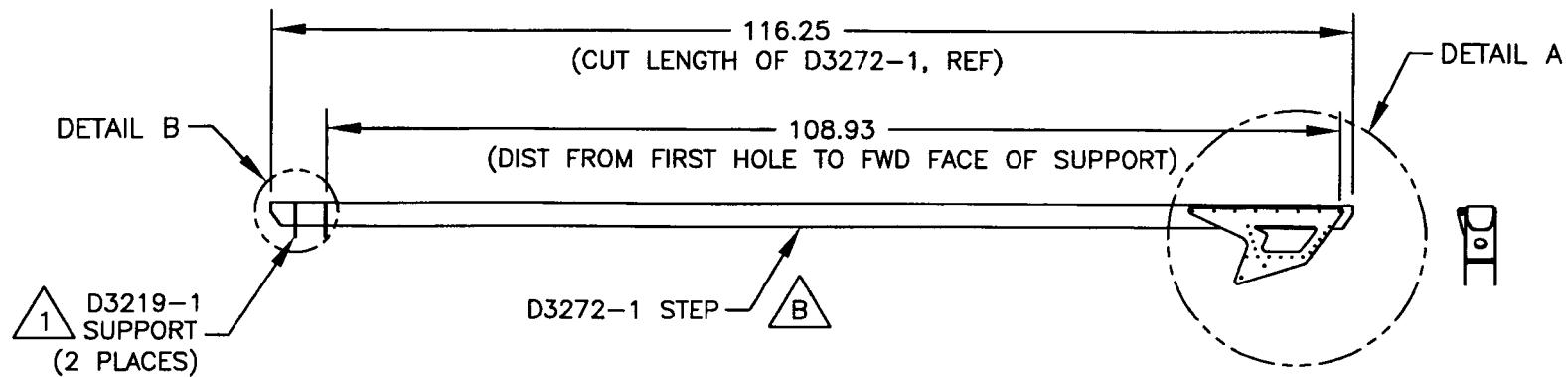
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

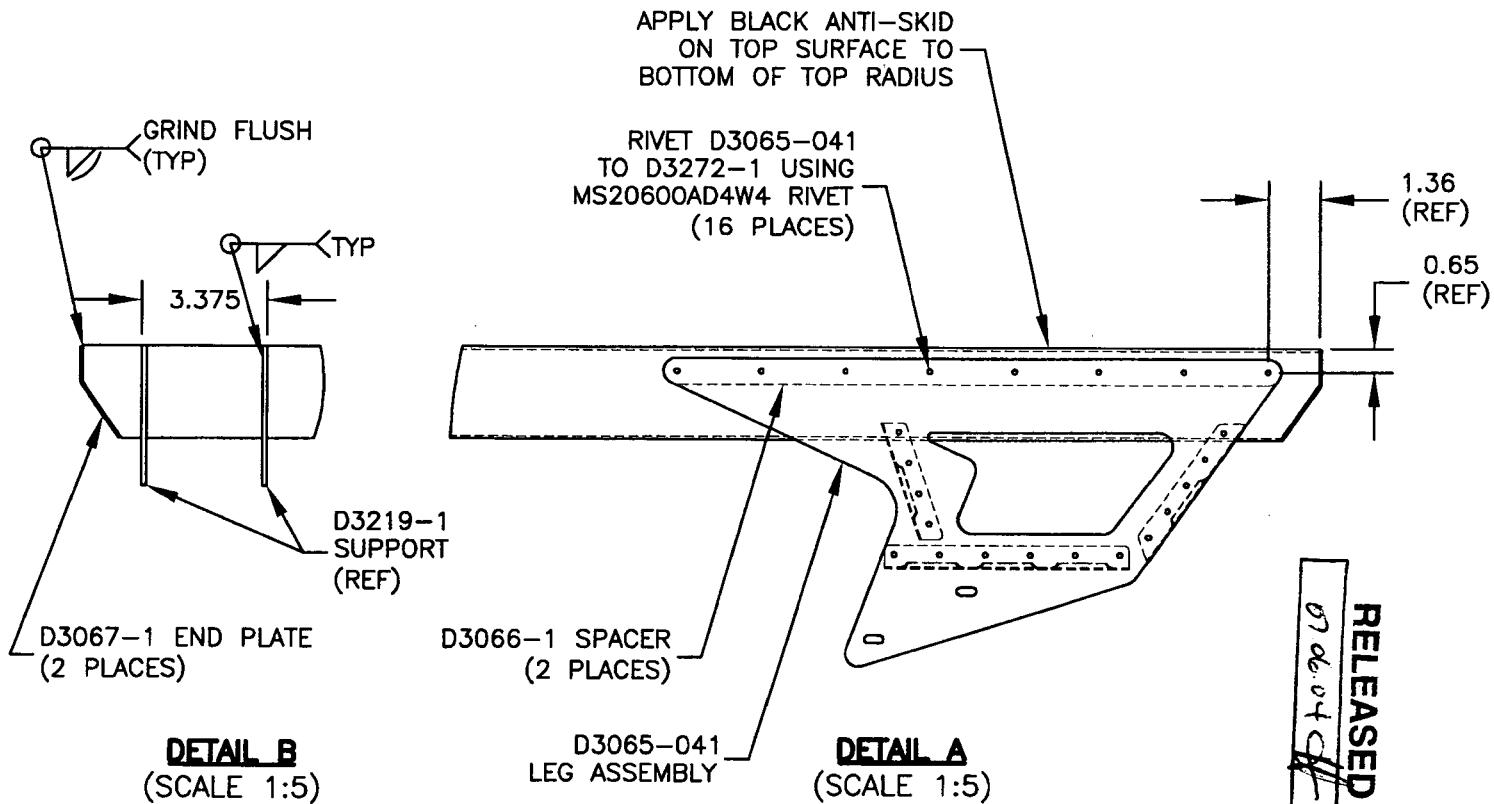
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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77358



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE		DRAWING NO.	REV. B
<i>CE</i>	<i>MM</i>	D3272	
07.05.18		STEP ASSEMBLY, LH LONG	SHEET 2 OF 3
			SCALE 1:20

W/O:		WORK ORDER CHANGES					
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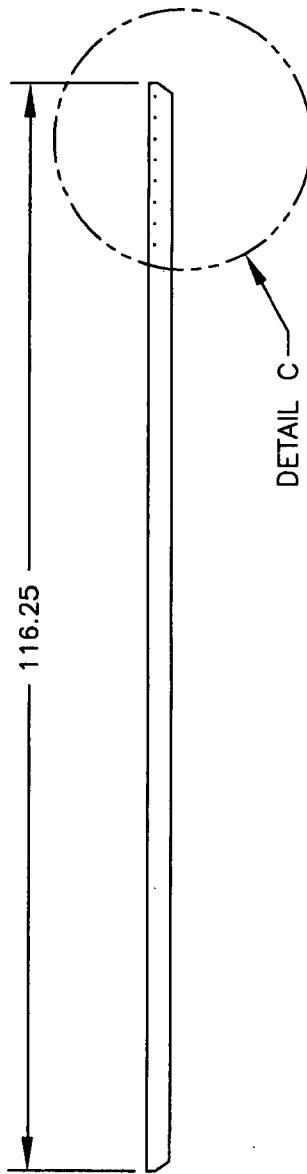
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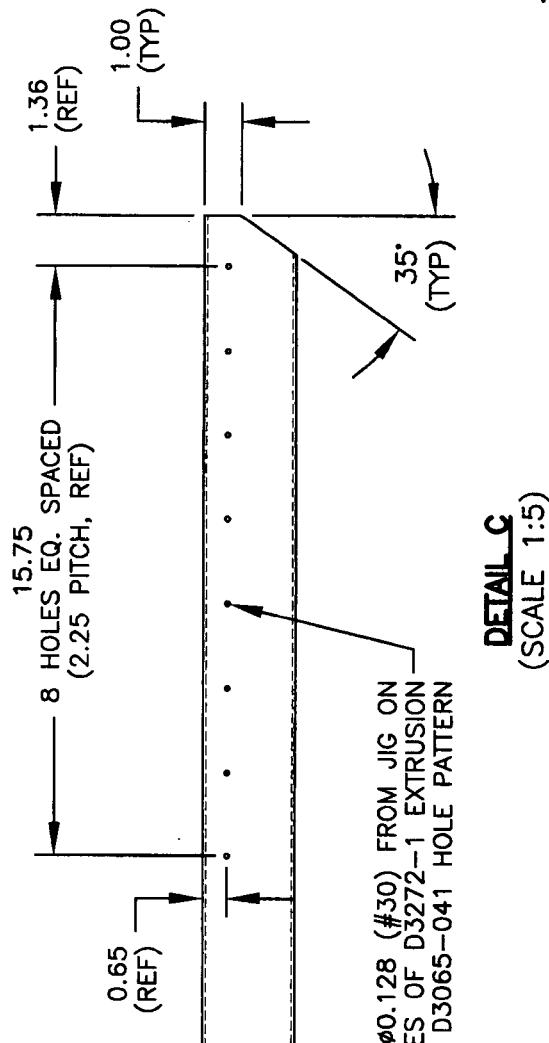
NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>SH</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

RELEASED

07.06.04 *SH*

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